

Work Order ID 128097

January-07-15 8:08:33 AM

128097

Page 1

Item ID: 646.9711

Revision ID:

Item Name: Blade

Start Date: 1/07/15

Start Qty: 30.00

Required Date: 1/16/15

Req'd Qty: 30.00

Reference:

Accept

N900040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

646.9700

C (ECN)

100

0.00

100

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut Blank at 4.625"

30

0

JPC 2015-01-07

110

0.00

110

HAA5 CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine per folio FB135

DWG REV: C

FOLIO REV: C

15/01/08

30

2- deburr and break all sharp edges except otherwise noted

KNIFE EDGE MUST BE SHARPENED USING STONE, REMOVE ALL
BURRS ON CUTTING EDGE

January-07-15 8:08:33 AM

Page 2

Accept

Setup Start *NS1*

Stop *NS2*

Start Date: 1/07/15 **Start Qty:** 30.00 ***30***

Cust Item ID:

Required Date: 1/16/15 **Req'd Qty:** 30.00 ***30***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ Run Start *NR1*
 QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

15/01/08

30

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

DAS
40
9-89

30

140

Outsource process - Heat Treat

0.00

140

Outsource1

Memo

0.00

Outsource process - Heat Treat

HEAT TREAT AS PER DWG, SEE NOTE #3

ISSUE P/O: 27040

CL 15/01/18 30

Work Order ID 128097

128097

January-07-15 8:08:33 AM

Page 3

Item ID: 646.9711 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Blade
 Start Date: 1/07/15 Start Qty: 30.00 ***30*** Cust Item ID:
 Required Date: 1/16/15 Req'd Qty: 30.00 ***30*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Receive & Inspect for Damage & Mat'l Certs	0.00							
150									
Packaging	Memo	0.00							
Packaging									
155	QC5- Inspect part completeness to step on W/O	0.00							
155									
QC	Memo	0.00							
Quality Control									
160	Spray Painting per QSI005 4.2	0.00							
160									
SprayPaint	Memo	0.00							
Spray Painting	PRIME AS PER DWG, SEE NOTE #4								
	PRIMER BATCH: <u>131121</u>								

30X SP15-01-26

30 DAS
38
9-89
JAN 26 2015

30 ER 150428

PTO

DQA:

Date: 15/03/19



QA Closed:

Date: 15/03/18

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only ☐

Work Order: <u>6128097</u>	DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS			
Part No. <u>646.9711</u>		Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
NCR No. <u>15-4650</u>		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐
		Thermoforming ☐	Finishing ☒	Rec/Store/Packaging ☐	Other ☐
		Large Fab ☐	Composite ☐	Supplier ☐	

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	15-01-29	160	5	Blades where put on cardboard when paint was still wet R.C. operator	5 02012 15/01/29	Scuff part and re paint Touch up w. Scuff lightly + sand up primer.	DAS 41 9-89 15-2-6	DAS 38 9-89 FEB 13 2015	5 02012 15/01/29
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator ☒									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	General		
☐ Bending	☐ Bend	☐ Folio/Program	☐ Outside Dimensions
☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance
☐ Cracks	☐ Broken/Damage/Defect	☐ Hardware	☐ Part Incorrect
☐ Crimp/Kink/Ripple/Wave	☐ Burrs	☐ Inspection Incomplete/Unqualified	☒ Temperature/Cure
☐ Cuffs	☐ Contamination	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing
☐ Crushing	☐ Countersink	☐ Misaligned/off center	☐ Part Moved
☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Positioned Wrong
☐ Inspection Strip in Tube	☐ Drawing	☐ Misread	☐ Power Loss/Surge
☐ Marks/Chatter	☐ Drill Holes	☐ Off-set	☐ Pressure/Forced
☐ Turning Sequence	☐ Finish	☐ Out of Calibration	☐ Set-up
☐ Wave/Twist in Tube	☐ Fit/Function	☐ Out of Sequence	☐ Weld
			☐ Wrong Stock Pulled
			☐ Other

Work Order ID 128097

128097

January-07-15 8:08:33 AM

Page 4

Item ID: 646.9711 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Blade
 Start Date: 1/07/15 Start Qty: 30.00 ***30*** Cust Item ID:
 Required Date: 1/16/15 Req'd Qty: 30.00 ***30*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC14- Inspect Spray Paint	0.00				<u>30</u>			<u>38</u> 9-88
170									
QC	Memo	0.00							
Quality Control									FEB 13 2015
180	Identify as per dwg & Stock Location: <u>MF</u>	0.00							
180						<u>30</u>			<u>AS</u>
Packaging	Memo	0.00							15-2-13
Packaging									
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

15/2/17 df
15-2-13

Picklist Print

January-07-15 8:08:32 AM

Page 1

Work Order ID: 128097

128097

Parent Item: 646.9711

646 9711

Parent Item Name: Blade

Start Date: 1/07/15

Required Date: 1/16/15

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP REV:A NEW ISSUE 12/09/24 JFS VERIFY BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MSTEEL-A2- B0.500X1.250		Purchased	No			100	f	106.9000	0.386	13			

MSTFFI -A2-B0 500X1 250

AISI A2 TOOL STEEL BAR, 0.500 X 1.250

Location

Loc Qty

Loc Code

MAT010

106.9

M126438

105.5

M127494

1.4

13

JK 2015-01-07

APICAL

INDUSTRIES, INC.

ENGINEERING CHANGE NOTICE NO.

04559

SHEET 1 OF 1

DWG NO. 646.9700

REV: C

PREPARED BY

D. MEJIA

DATE: 06/11/2014

EFFECT ON DWG

☐ INC. ☒ UNINC.

DWG TITLE: CUTTER SUB ASSY

APPROVED BY:

ENGR

[Signature]

MFG

[Signature]

QC

[Signature]

EFF.

NEXT ORDER

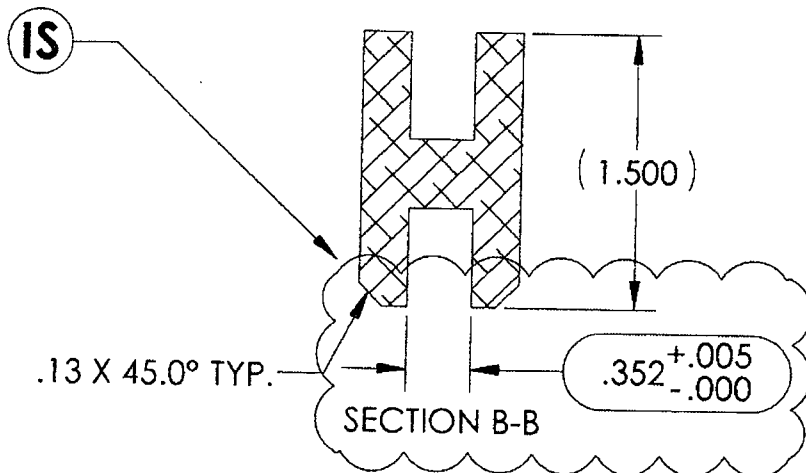
TRANSACTION CODES (TC):
A-ADD
R-REVISE
C-CREATE
D-DELETE

REASON: ADDED DIMENSION AND TOLERANCE

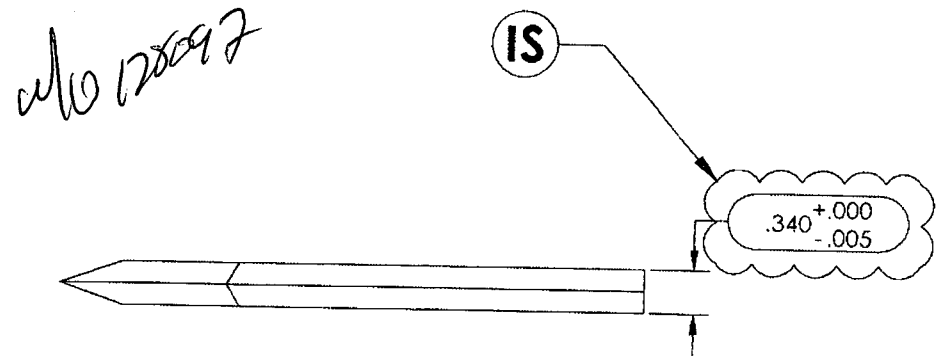
ECR:

D-14-05

SHEET 2, ZONE D7 IS:



SHEET 5, ZONE B5 IS:



DOCUMENTS EFFECTED:

☐ MDL ☐ INSTALL INSTRUCTIONS ☐ ICA ☐ FMS ☐ BOM

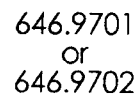
CHANGE CATEGORY

☐ MAJOR ☒ MINOR

DER REVIEW REQUIRED

☐ YES ☒ NO

REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
	LAST PROJECT REVISION: P2		NAC
	INITIAL RELEASE	03/29/09	P. BRAVO
A	INCORPORATED ECH 02744, 03036, 03912	06/01/13	P. BRAVO
B	INCORPORATED ECH 03967	07/03/13	P. BRAVO
C	INCORPORATED ECH 04039	08/09/13	P. BRAVO



① MATERIAL: ALUMINUM 7075-T651 PER AMS-QQ-A-250/12

② FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III,
CLASS 2, COLOR BLACK;
PRETREAT PRC-DESOTO PR-148 ADHESION PROMOTER;
PRIME IAW MIL-P-23377J TYPE I CLASS N; 1-2 MIL MAX

③ MATERIAL: AISI A2 TOOL STEEL
CONDITION: ANNEALED
POST PROCESS: HEAT TREAT TO 58-62 Rc ROCKWELL HARDNESS

④ FINISH: PRIME IAW MIL-P-23377J TYPE I CLASS N; 1-2 MIL MAX

5. DEBURR AND BREAK ALL SHARP EDGES EXCEPT WHERE OTHERWISE NOTED

6. IDENTIFY IAW MPP-120

⑦ APPLY F/N 5 AS REQUIRED TO ALL FAYING SURFACES OF F/N 2 UPON ASSEMBLY

⑧ CUTTING EDGE INTENDED TO BE SHARP, DO NOT BREAK SHARP EDGE

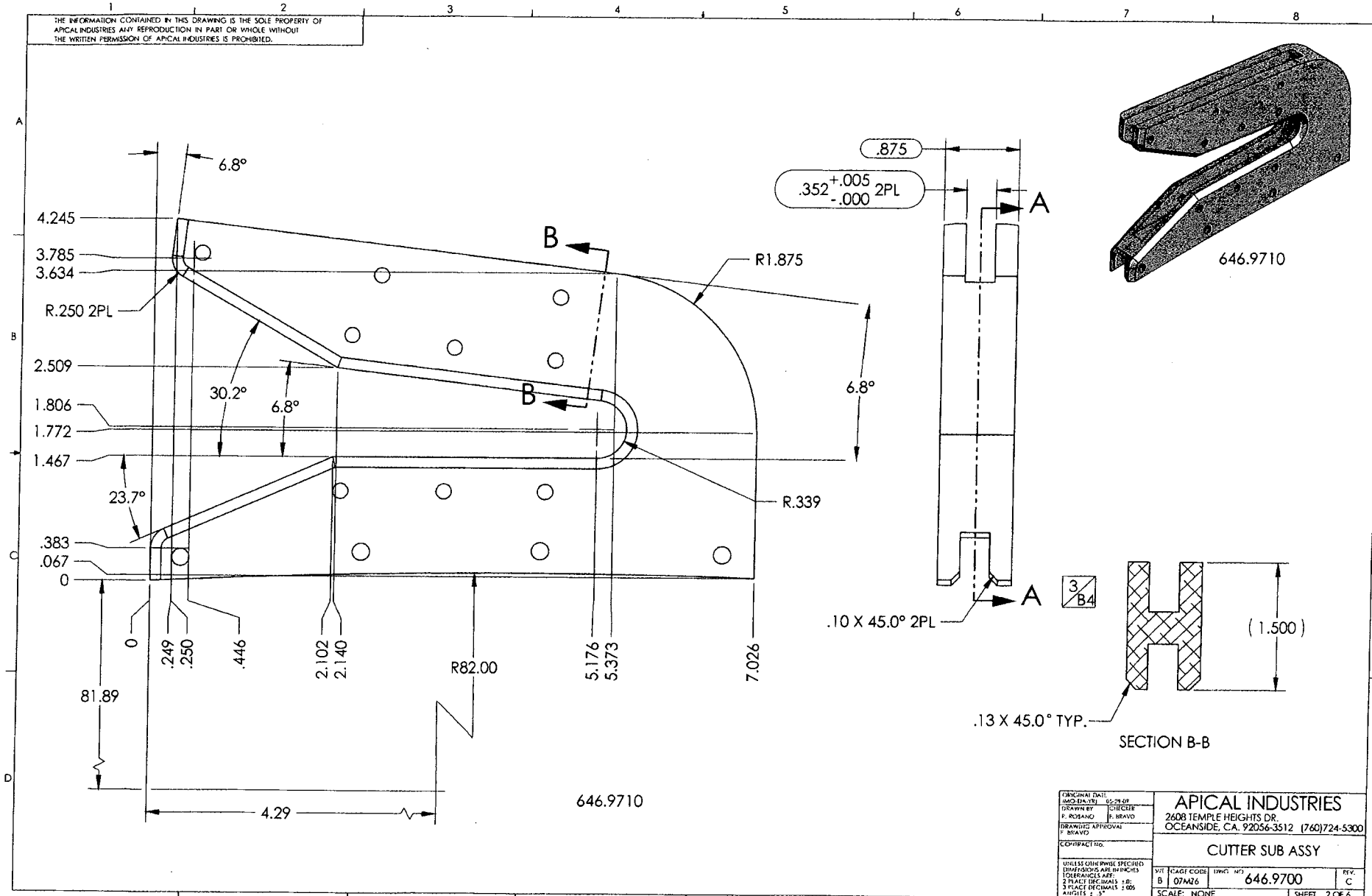
⑨ ALL DIMENSIONS NOT SPECIFIED ARE CONTROLLED BY 646.9710.

UNINCORPORATED ECN(S)

0455

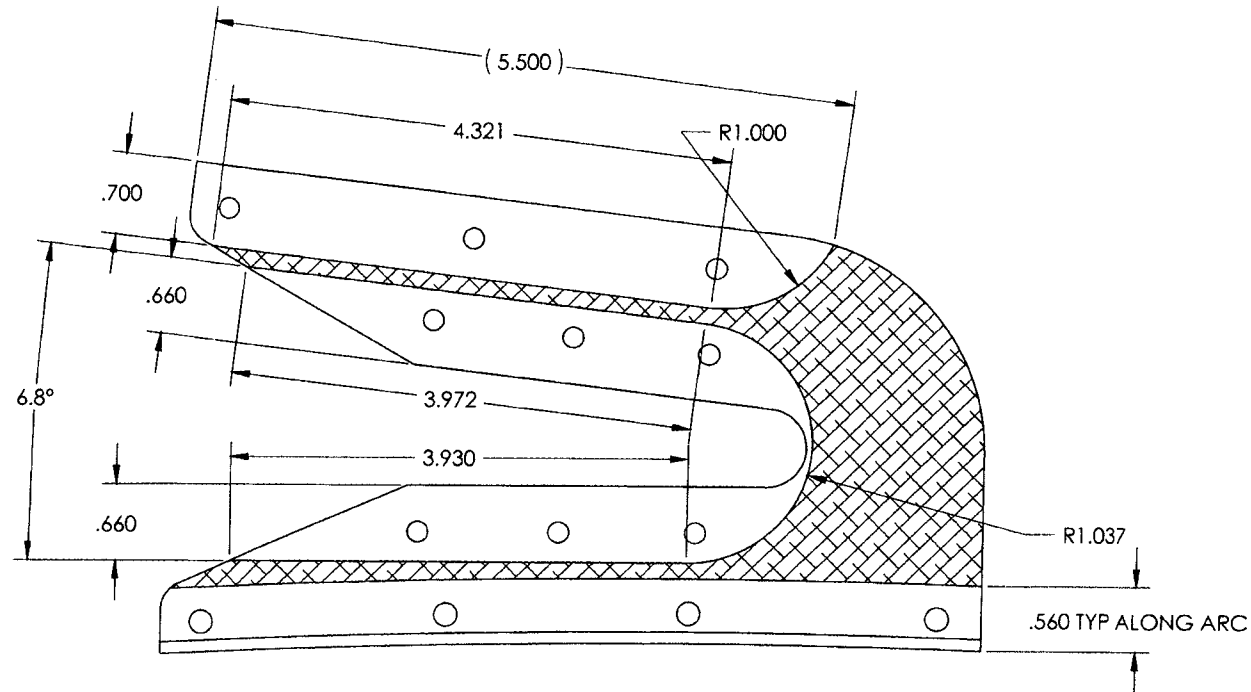
1		7	646.9712	BODY (U CHANNEL)	△	△
6	6	6	601.1541	LOCKNUT	M521042108	
A/R	A/R	5	601.2764	RTV, LOCITE 598		
12	12	4	601.2764	WASHER	1A51149/H832F	
6	6	3	601.2765	SCREW	M527039/0819	
2	2	2	646.9711	BLADE		
	1	1	646.9710	BODY	△	△
			646.9702	CUTTER SUB ASSY (U CHANNEL)	△	△
			646.9701	CUTTER SUB ASSY		
S702	S703	FIND #	PART #	DESCRIPTION	MATL	SPEC.
QTY				PARTS LIST		
NEXT ASSY (S)				APICAL INDUSTRIES		
646.9600				2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA 92056-3512 (760)724-5300		
ORIGINAL DATE 02-29-90 DRAWN BY: R. ROJAS CHECKED BY: R. ROJAS DRAWING APPROVAL 02-29-90 CONTRACT NO.				CUTTER SUB ASSY MFG. CAGA CORP. INQ. NO. 3 8 07M26 SCALE NONE 646.9700		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: FRACTIONS DECIMALS ±.005 ANGLES ± .5°				MFG. CAGA CORP. INQ. NO. 3 8 07M26 SCALE NONE 646.9700		
				SHEET 1 OF 4 C		

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THE WRITTEN PERMISSION OF APICAL INDUSTRIES IS PROHIBITED.



ORIGINAL DATE (MM-DD-YY) 05-28-09		APICAL INDUSTRIES	
DRAWN BY CHUCKIE		2608 TEMPLE HEIGHTS DR.	
P. ROIANO J. BRAVO		OCEANSIDE, CA 92056-3512 (760)724-5300	
DRAWING APPROVAL J. BRAVO		CUTTER SUB ASSY	
CONTRACT NO.		646.9700	
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°		V/E (CAGE CODE) (WGT. LBS.) B 07M16	REV. C
SCALE: NONE		SHEET 2 OF 6	

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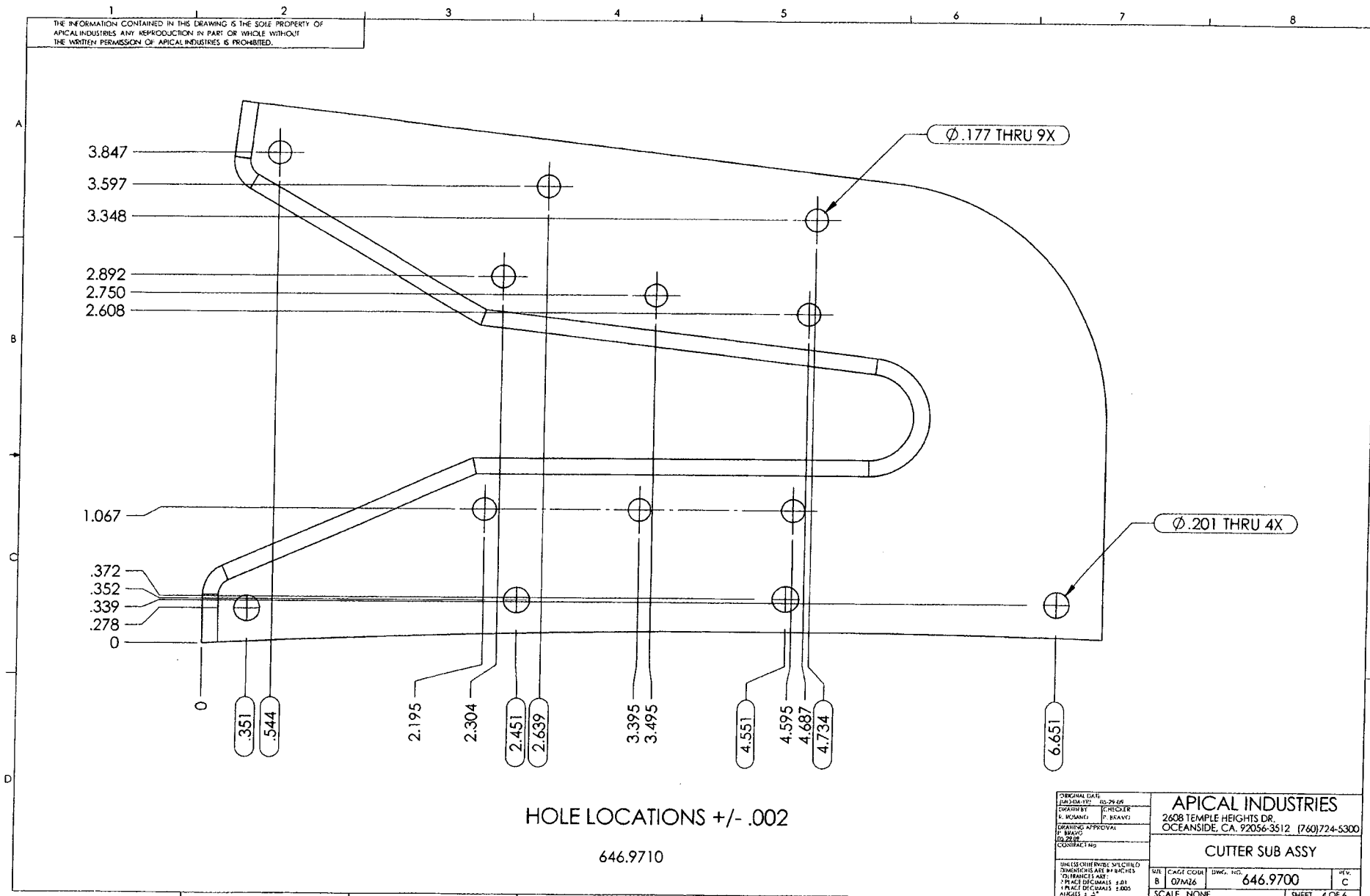


SECTION A-A $\frac{2}{C6}$

646.9710

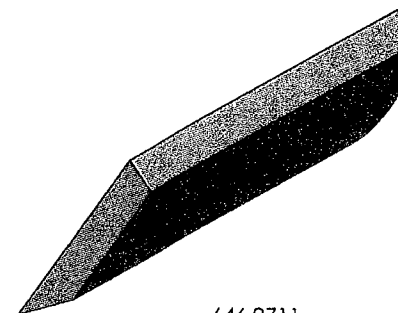
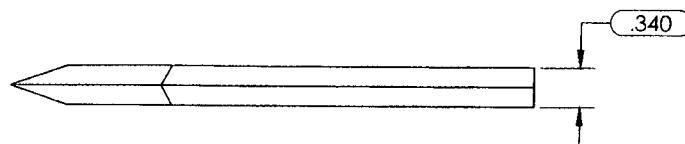
ORIGINAL DATE ENC 64-197 00-2945		APICAL INDUSTRIES	
DRAWN BY P. BRYAN		2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
CHECKED BY P. BRYAN		CUTTER SUB ASSY	
DRAWING APPROVAL P. BRYAN		SCALE NONE	
CONTACT NO.		SHEET 3 OF 6	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°		DWG. NO. 646.9700	
SHEET 07M26		REV. C	

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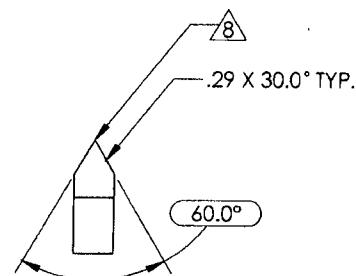
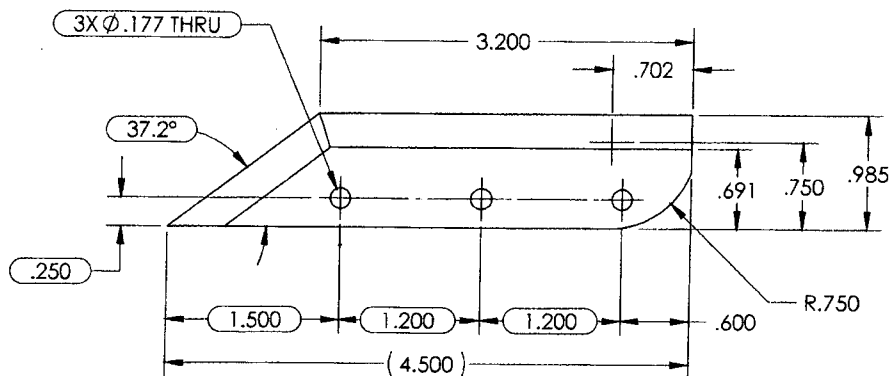


ORIGINAL DATE: 10-24-06		DWG. NO. 646.9700	
DRAWN BY: S. MCNAMEE	CHECKED: J. HANCOCK	REV. C	
DRAWING APPROVAL: J. BRADY		SCALE: NONE	
ID: 2016 CONTRACTING		SHEET 4 OF 6	
APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300 CUTTER SUB ASSY			

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646.9711



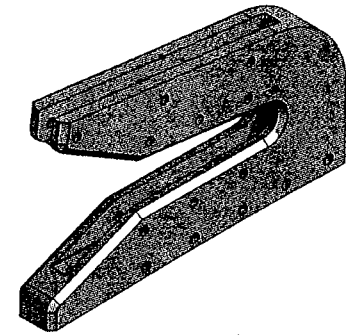
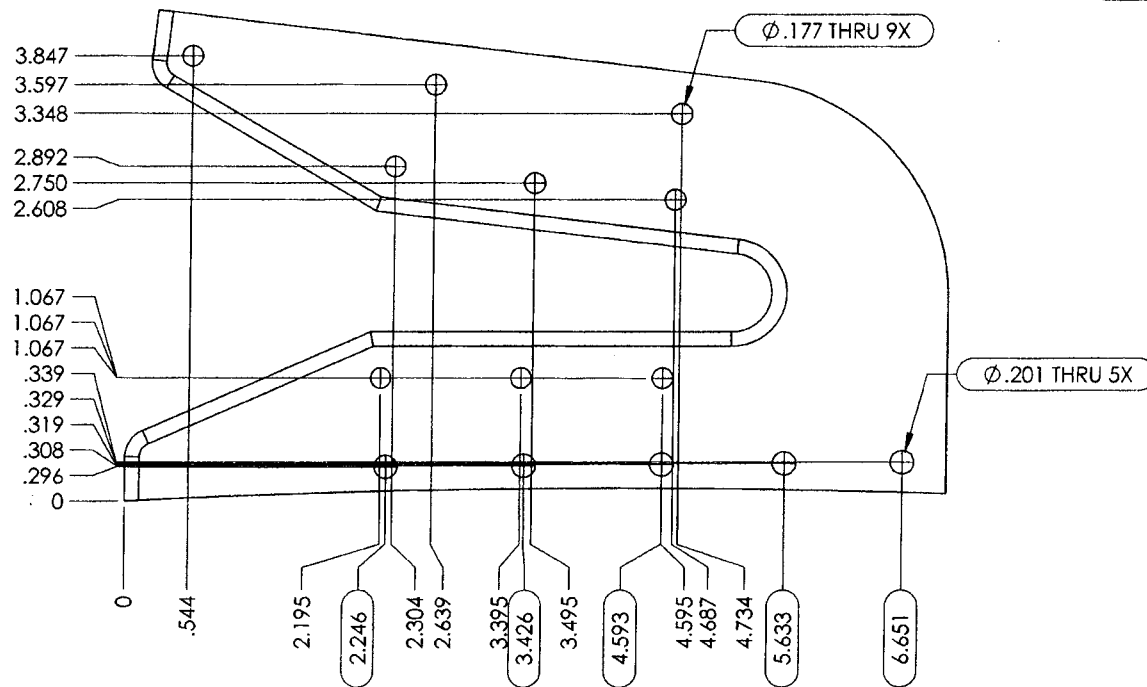
646.9711

ORIGINAL DATE (REV. DATE)	05-20-09	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA 92056-3512 (760) 474-5300			
DRAWN BY	CHIEF				
BY	P. BEAUG				
DRAWING APPROVAL	P. BEAUG				
DATE	05-20-09				
CONTRACT NO.		CUTTER SUB ASST			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS $\pm .01$ 3 PLACE DECIMALS $\pm .001$ ANGLES $\pm .5^\circ$					
SHEET	CAGE CODE			DWG. NO.	REV.
B	07M26			646.9700	C
SCALE				NONE	SHEET 5 OF 6

APICAL INDUSTRIES
2608 TEMPLE HEIGHTS DR.
OCEANSIDE, CA. 92056-3512 (760)724-5300

CUTTER SUB ASSY

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646.9712 $\triangle 9$

646.9712

ORIGINAL DATE: 05-29-09		APICAL INDUSTRIES	
DMD. DA YPI		2608 TEMPLE HEIGHTS DR.	
DRAWN BY: K. RUSAKO		OCEANSIDE, CA. 92056-3512 (760)724-5300	
CHECKED BY: P. BRAND		CUTTER SUB ASSY	
DRAWING APPROVAL: P. BRAND 05-29-09		UNLESS OTHERWISE SPECIFIED	
CONTRACT NO.		DIMENSIONS ARE IN INCHES	
		FOR BRANCES ARE:	
		2 PLACE DECIMALS $\pm .03$	
		3 PLACE DECIMALS $\pm .005$	
		ANGLES $\pm .5^\circ$	
REV. C	CAGE CODE: 07M26	ENG. NO. 646.9700	SCALE: NONE
		SHEET 6 OF 6	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO27040**

Purchase Order Date 1/13/2015

PO Print Date 1/13/2015

Page Number 2 of 3

Order From :

VC-MET004

METCOR INC.
560 BOUL. ARTHUR SAUVE
SAINT-EUSTACHE, QC J7R 5A8
CA

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone

450 473 1884

Ship To Contact

Ship To Phone

Ship Via:

FedEx Overnight collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

FCA - (Free Carrier)

Line Total:

\$0.00

127462

646.3316 BLADE

1/23/2015

10.00

\$0.00

\$0.00

Yes

1/23/2015

FINISH: HEAT TREAT TO 58-62 RC
ROCKWELL HARDNESS

PART ARE MADE FROM AISI A2 TOOL STEEL

PLEASE NOTE: DETAIL C OF C REQUIRED

Line Total:

\$0.00

128097

646.9711 BLADE

1/23/2015

30.00 ✓

\$0.00

\$0.00

Yes

1/23/2015

FINISH: HEAT TREAT TO 58-62 RC
ROCKWELL HARDNESS

PART ARE MADE FROM AISI A2 TOOL STEEL

PLEASE NOTE: DETAIL C OF C REQUIRED

Line Total:

\$0.00

Note:

1/13/2015

8015-01-26

METCOR INC.

560 BOULEVARD ARTHUR SAUVÉ
 ST-EUSTACHE, Q.C. J7E 8A8
 Tel: 450-473-1884 / Fax: 450-481-5498

Reçu de livraison

Delivery Receipt

BON DE TRAVAIL Order	EXPÉDITEUR Shipper ID	BON D'EXPÉDITION Shipper
201869	1	87675

EXPÉDITION COMPLÈTE / Shipped Complete

CLIENT / Customer 215

DART AEROSPACE
 1270 ABERDEEN
 HAWKESBURY ON K6A 1K7
 Ph: 613-632-5200
 Fax: 613-632-1053

LIVRE À / Shipped To

DART AEROSPACE
 1270 ABERDEEN
 HAWKESBURY ON K6A 1K7
 Ph: 613-632-5200
 Fax: 613-632-1053



COMMANDE DU CLIENT Customer PO	BON DE LIVRAISON DU CLIENT Customer Shipment No	TYPE DE MATÉRIEL Material Type	DATE DE LA COMMANDE Order Date	TRANSPORTEUR Carrier
27040		A2	2015/1/13	client

QUANTITÉ Quantity	No. PIÈCE Part No	NOM DE LA PIÈCE Part Name	DESCRIPTION DE LA PIÈCE Part Description	POIDS Weight
----------------------	----------------------	------------------------------	---	-----------------

74 646 3316

23,

(10) 646 3316 127462

(30) 646 9711 128097

(10) 646 9711 127326

(12) 646 3013 127805

(12) 646 3314 127669

805-01-26

2-BOITE DE CARTON

TYPE DE CONTENEUR Container Type	# DE CONTENEURS # Of Containers	COMMENTAIRES CONTENEUR Container Comments
-------------------------------------	------------------------------------	--

BOITE DE CARTON

2

CERTIFICAT

EMPAQUETAGE Packing	
------------------------	--

QUANTITÉ EXPÉDIÉE / Quantity Shipped

74

POIDS EXPÉDIÉ / Weight Shipped

23,00

QUANTITÉ RESTANTE / Quantity Remaining

0

POIDS RESTANT / Weight Remaining

0,00

CERTIFICAT

QUANTITÉ EXPÉDIÉE / Quantity Shipped

74

POIDS EXPÉDIÉ / Weight Shipped

23,00

Signature:

Date:

EXPÉDIÉ LE / Shipped On: 2015/01/16

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Rapport d'Inspection**Inspection Report**

BON DE TRAVAIL order	CHARGES load
201869	

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

COMMANDE DU CLIENT customer po	BON DE LIVRAISON DU CLIENT customer shipper no.	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
27040		A2		

SPÉCIFICATIONS DU PROCÉDÉ
processing specifications

VAC HARDEN

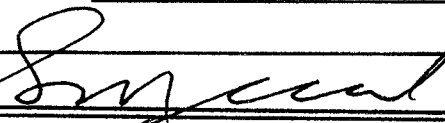
HARDEN AND TEMPER

EXIGENCE / requirement	SPÉCIFICATIONS / specified	TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results
HARDNESS	58 - 62 HRC	8	60 - 62 HRC

QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description
74	23	646.3318 (10) 646.3318 127462 (30) 646.9711 128097 ✓ (10) 646.9711 127326 (12) 646.3013 127805 (12) 646.3314 127669 2 BOITE DE CARTON

SP15-01-26

28 Jan

COMMENTAIRES / comments**APPROUVÉ par / Approved by:****DATE: 2015-01-16**

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Certificat de Conformité Détail

Detailed Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
201869	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

1

COMMANDE DU CLIENT customer po	BON DE LIVRAISON DU CLIENT customer shipper no.	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
27040		A2		
SPÉCIFICATIONS DU PROCÉDÉ processing specifications				
VAC HARDEN				
HARDEN AND TEMPER				
EXIGENCE / requirement	SPÉCIFICATIONS / specified	TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results	
HARDNESS	58 - 62 HRC	8	60 - 62 HRC	
QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description		
74	23	646.3316 (10) 646.3316 127462 (30) 646.9711 128097 (10) 646.9711 127326 (12) 646.3013 127805 (12) 646.3314 127669 2 BOITE DE CARTON		

COMMENTAIRES / comments

DOUBLE TEMPER 400F, 2 HRS

Le traitement thermique (TT) a été fait en utilisant des équipements en conformité avec la spécification demandée. Toutes les opérations de TT ont été faites en conformité avec les requis de la spécification demandée et toutes les vérifications et les tests demandés ont été faites et documentés. Aucun changement n'a été faite par rapport au TT. On certifie que le matériel a été fabriqué, échantillonné, testé et inspecté en accord avec les spécifications du matériel et le bon de commande et le matériel rencontre les exigences spécifiées.

Heat treatment (HT) was performed with equipment that meets the requirements of requested specification. All HT operations were performed in compliance with the required HT specification and all verifications have been performed and documented. No unauthorized changes were performed in regards to the HT. We certify that the material was manufactured, sampled, tested and inspected in accordance with the material specification and the purchase order and was found to meet the requirements.

APPROUVÉ par / Approved by:

Isabel Otero

Isabel Otero
QA Technician

DATE: 2015-01-16

